



Dart Aerospace Ltd.
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Tel (613) 632-5200

D5134-041
Job Sheet 177188



Part No: D5134-041

Job Qty: 8 ea

Part Name: Damper Support Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	6/12/18	6/12/18	0.00	0.00	Start Up Machining-3		SBL 18/06/00
100	Bandsaw	8 pcs	6/12/18	6/12/18	0.00	0.47	Bandsaw1		SBL 18/06/10
110	CNC Vertical Machining	8 pcs	6/12/18	6/12/18	1.03	18.60	HAAS1-4		SBL 18/06/09
120	QC	8 pcs	6/12/18	6/12/18	0.00	0.00	QC2 Machining-3		SBL 18/06/10
130	QC	8 pcs	6/12/18	6/12/18	0.00	0.00	QC8 Machining-3		SBL 18/06/11
135	HandFinish	8 pcs	6/12/18	6/12/18	0.00	0.53	HandFinish1		SA 18-06-12
137	QC	8 pcs	6/12/18	6/12/18	0.00	0.00	QC7-4		AS JUN 13 2018
140	SprayPaint	8 pcs	6/12/18	6/12/18	0.00	2.08	Spray Paint		Jmo 13/06/2018
150	QC	8 pcs	6/12/18	6/12/18	0.00	0.00	QC14		AS JUN 16 2018
160	Small Fab	8 pcs	6/12/18	6/12/18	0.00	1.15	Small Fab-8		SMB
170	QC	8 pcs	6/12/18	6/12/18	0.00	0.00	QC5		AS JUN 21 2018
180	Packaging	8 pcs	6/12/18	6/12/18	0.00	0.00	Packaging3-2	LG054	AS JUN 21 2018
190	QC21-SA	8 Ea	6/12/18	6/12/18	0.00	0.00	QC21		21 JUN 21 2018

Part Op 100 - CUT BLANK TO 5.125" LONG *****CHECK GRAIN DIRECTION*****

Descriptions: 110 - Mill as per Dwg and folio FB342

140 - ***MASK BEARING HOLE AS PER NOTE 2*** PRIME AS PER DWG AND QSI BATCH: 138847 PAINT AS PER DWG AND QSI BATCH: 138863

160 - install bushings as per dwg

180 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B3.000X4.000	7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"	3.4160 ft (.427 ea)	90-Start up Operation	
NAS77C6-021	Bushing	16 Ea (2 ea)	160-Small Fab	se fm 134703
F4138252 -> 5079481				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B3.000X4.000	3	0	0
160-Small Fab	NAS77C6-021	16	283	0



Container No: S079482



Part: D5134-041

Job No: 177188

Serial No/Batch: S079482

Revision:

Inspector:

Exp Date:

Instructions:

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Date: 06/10/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Damper Support Assembly, LH	0.360Inches $\pm$ 0.030	0.390 0.330		
2	Damper Support Assembly, LH	0.188Inches $\pm$ 0.005 - 0.001	0.193 0.187		
3	Damper Support Assembly, LH	0.257Inches $\pm$ 0.006 - 0.001	0.263 0.256		
4	Damper Support Assembly, LH	1.932Inches $\pm$ 0.010	1.942 1.922		
5	Damper Support Assembly, LH	0.632Inches $\pm$ 0.010	0.642 0.622		
6	Damper Support Assembly, LH	0.632Inches $\pm$ 0.010	0.642 0.622		
7	Damper Support Assembly, LH	0.730Inches $\pm$ 0.010	0.740 0.720		
8	Damper Support Assembly, LH	0.500Inches $\pm$ 0.000 - 0.010	0.500 0.490		
9	Damper Support Assembly, LH	0.100Inches $\pm$ 0.010	0.110 0.090		
10	Damper Support Assembly, LH	0.728Inches $\pm$ 0.010	0.738 0.718		
11	Damper Support Assembly, LH	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	
12	Damper Support Assembly, LH	0.630Inches $\pm$ 0.030	0.660 0.600	Radius	
13	Damper Support Assembly, LH	0.063Inches $\pm$ 0.010	0.073 0.053	Radius	
14	Damper Support Assembly, LH	0.117Inches $\pm$ 0.010	0.127 0.107		
15	Damper Support Assembly, LH	0.177Inches $\pm$ 0.010	0.187 0.167		
16	Damper Support Assembly, LH	0.841Inches $\pm$ 0.010	0.851 0.831		
17	Damper Support Assembly, LH	0.208Inches $\pm$ 0.010	0.218 0.198		
18	Damper Support Assembly, LH	0.208Inches $\pm$ 0.010	0.218 0.198		
19	Damper Support Assembly, LH	0.860Inches $\pm$ 0.010	0.870 0.850		
20	Damper Support Assembly, LH	1.471Inches $\pm$ 0.010	1.481 1.461		
21	Damper Support Assembly, LH	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	

Plex 5/8/18 10:28 AM Dart.Gagnon.Michelle

